

Date: Thursday, 20/11/2008 3:36:33 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ACCESS PANEL ASSEMBLY
Job Number :	43640		
Estimate Number :	12948		
P.O. Number :		Part Number :	D3259041
This Issue :	20/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3249 REV A1
First Issue :	//	Project Number :	N/A
Previous Run :	34240	Drawing Revision :	A1
Written By :		Material :	
Checked & Approved By :	JLD 08.11.21	Due Date :	21/12/2008
Comment :	Est Rev:A New Issue 07-07-19 JLM Verified By:EC	Qty:	2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Assembly Kit

2.0	D32591	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 panel
 Batch: 34736x1 / B44301x2

FF 09-03-16

(3)

3.0	D32593	Doubler
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler
 Batch: B43772x1 / B44302x2

FF 09-03-16

(3)

4.0	D32595	Spacer
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer
 Batch: B34737x1 / B43774x2

FF 09-03-16

(3)

5.0	D32597	Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Door
 Batch: B34738x1 / B44304x2

FF 09-03-16

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:36:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 43640

Part Number: D3259041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D31615	Hinge 9.9"
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Hinge 9.9"

Batch: ~~43640~~ / ~~317360001~~

B 46473 FF 09-03-16

(3)

7.0	D32601	Spring
-----	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
Spring

Batch: B 43775 x 8 / ~~3447205 x 4~~

FF 09-03-16

(3)

8.0	127H5	HALF GROMMET
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
HALF GROMMET

Batch: m110118

FF 09-03-16

(3)

9.0	250018C3Y	RIGHT RECEPTACLE
-----	-----------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
RIGHT RECEPTACLE

Batch: 1105932

FF 09-03-16

(3)

10.0	2501W20020C3Y	STUD
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
STUD

Batch: M100398

FF 09-03-16

(3)

11.0	MS20426AD44	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)
Rivet

Batch: m15541

FF 09-03-16

(3)

12.0	MS20470AD34	Rivet, Universal Head
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Comment: Qty.: 36.0000 Each(s)/Unit Total: 72.0000 Each(s)
Rivet, Universal Head

Batch: M15541

FF 09-03-16

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:36:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 43640

Part Number: D3259041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	MS20470AD35	Rivet
------	-------------	-------



Comment: Qty.: 10.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivet

Batch: 119682

30.

FF 09-03-16

(3)

14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259.

Note: Keep .040" Gap all around door.

FF 09-03-16

(3)

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/03/16 (43)

16.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

9/3/16

(3x)

SP

17.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

09/03/18 JA

Job Completion



MF 09-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

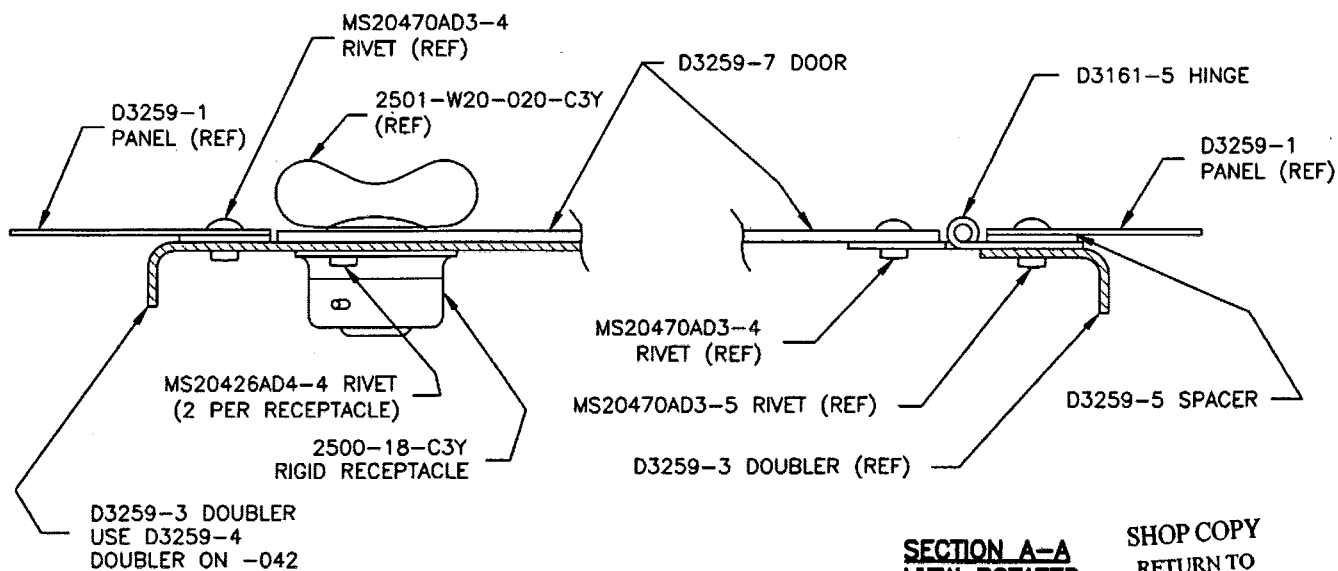
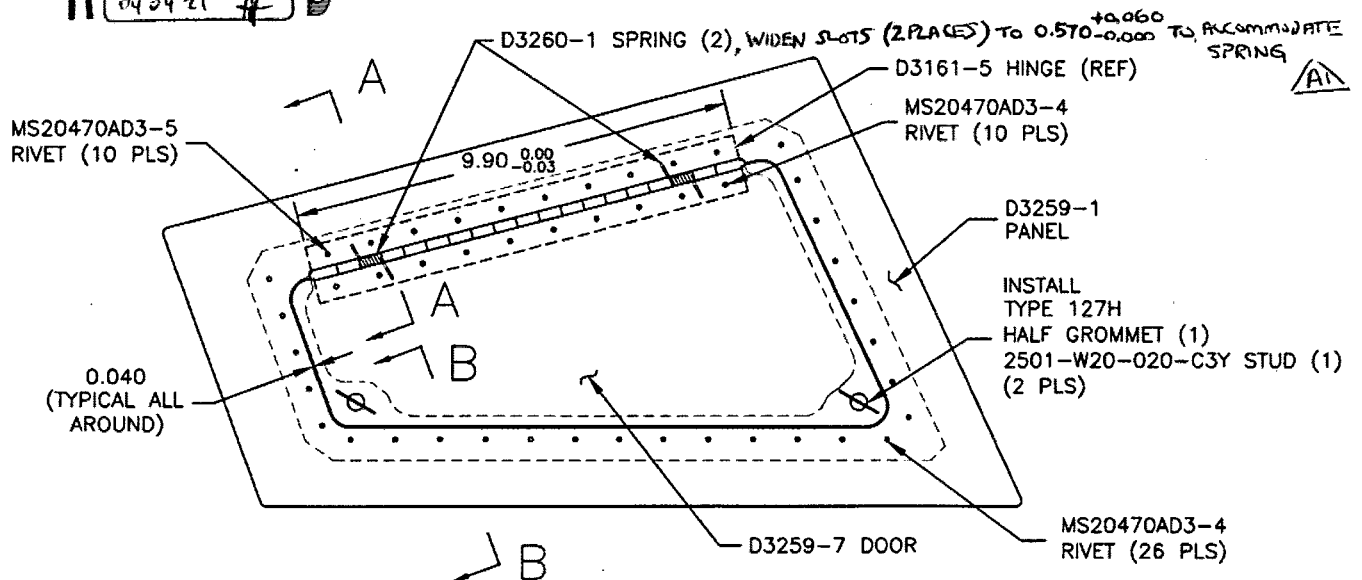
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	DRAWING NO. D3259
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY
A	04.02.25	NEW ISSUE	REV. A
AI	<i>[Signature]</i> 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING	SHEET 1 OF 6 SCALE 1:4

RELEASED
040421 *[Signature]*



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

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WORK ORDER
43640

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

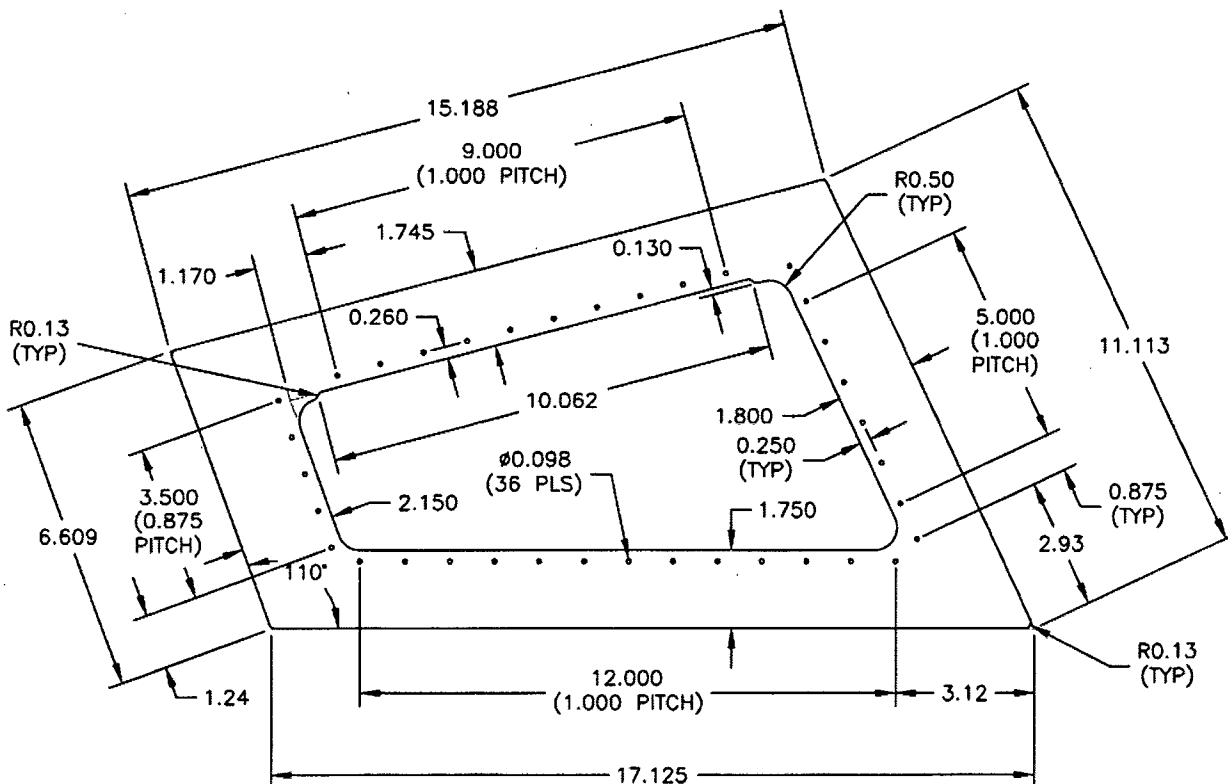
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CHECKED #	APPROVED #	DRAWING NO. D3259	REV. A SHEET 2 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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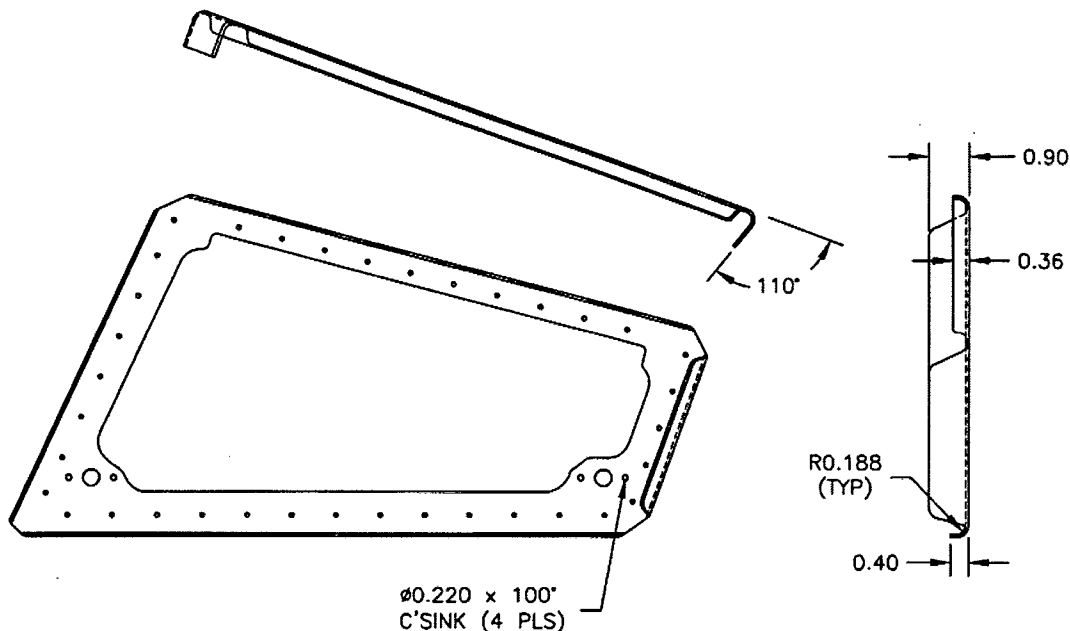
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)
BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.085)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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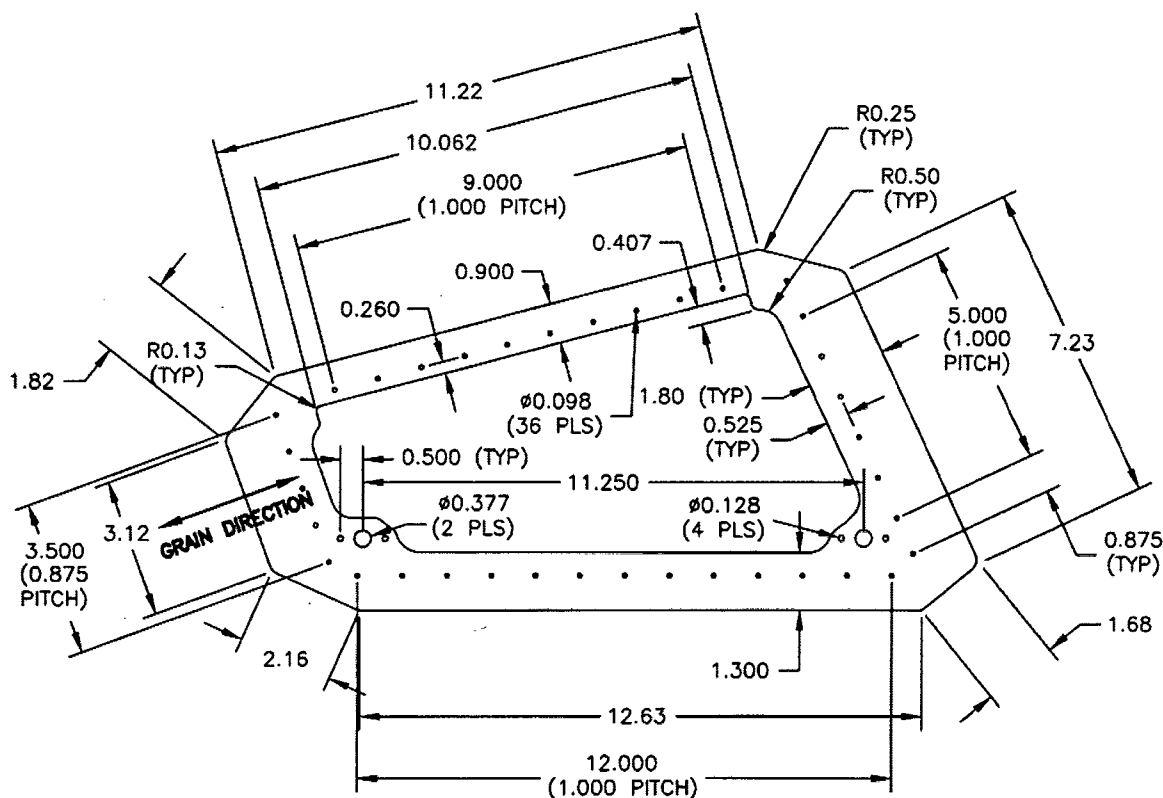
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 [Signature]



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

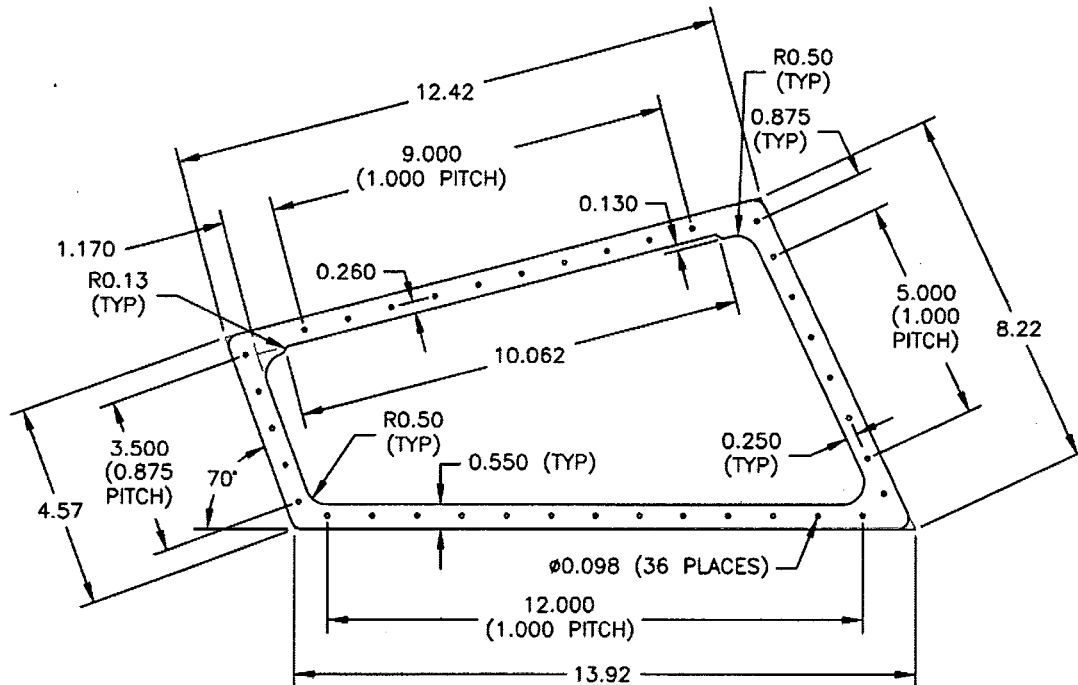
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RELEASED
04.04.05**D3259-5 SPACER**

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T35.052)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.3 SUBJECT TO AMENDMENT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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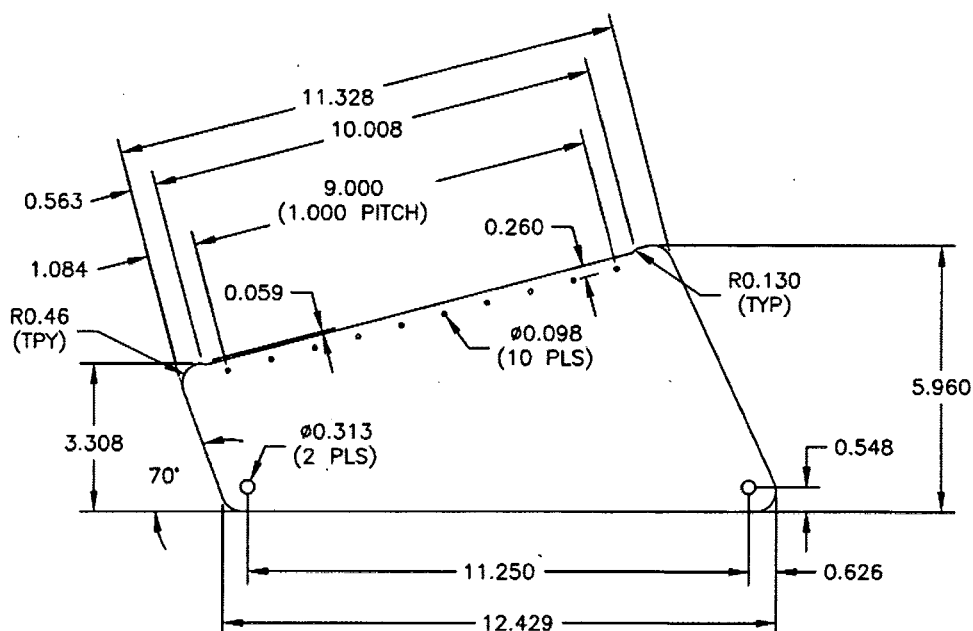
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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